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Notice of Allowability	Application No.	Applicant(s)	
	10/780,413	GREEN ET AL.	
	Examiner	Art Unit	
	Daniel C. Crane	3725	

-- The MAILING DATE of this communication appears on the cover sheet with the correspondence address--
 All claims being allowable, PROSECUTION ON THE MERITS IS (OR REMAINS) CLOSED in this application. If not included herewith (or previously mailed), a Notice of Allowance (PTOL-85) or other appropriate communication will be mailed in due course. **THIS NOTICE OF ALLOWABILITY IS NOT A GRANT OF PATENT RIGHTS.** This application is subject to withdrawal from issue at the initiative of the Office or upon petition by the applicant. See 37 CFR 1.313 and MPEP 1308.

1. ☒ This communication is responsive to Amendment filed January 26, 2006.
2. ☒ The allowed claim(s) is/are 2, 3, 6-8, 10-16, 19-45, 47-51 and 58-65.
3. ☐ Acknowledgment is made of a claim for foreign priority under 35 U.S.C. § 119(a)-(d) or (f).
 - a) ☐ All b) ☐ Some* c) ☐ None of the:
 1. ☐ Certified copies of the priority documents have been received.
 2. ☐ Certified copies of the priority documents have been received in Application No. _____.
 3. ☐ Copies of the certified copies of the priority documents have been received in this national stage application from the International Bureau (PCT Rule 17.2(a)).

* Certified copies not received: _____.

Applicant has THREE MONTHS FROM THE "MAILING DATE" of this communication to file a reply complying with the requirements noted below. Failure to timely comply will result in ABANDONMENT of this application.
THIS THREE-MONTH PERIOD IS NOT EXTENDABLE.

4. ☐ A SUBSTITUTE OATH OR DECLARATION must be submitted. Note the attached EXAMINER'S AMENDMENT or NOTICE OF INFORMAL PATENT APPLICATION (PTO-152) which gives reason(s) why the oath or declaration is deficient.
5. ☐ CORRECTED DRAWINGS (as "replacement sheets") must be submitted.
 - (a) ☐ including changes required by the Notice of Draftsperson's Patent Drawing Review (PTO-948) attached
 - 1) ☐ hereto or 2) ☐ to Paper No./Mail Date _____.
 - (b) ☐ including changes required by the attached Examiner's Amendment / Comment or in the Office action of Paper No./Mail Date _____.

Identifying indicia such as the application number (see 37 CFR 1.84(c)) should be written on the drawings in the front (not the back) of each sheet. Replacement sheet(s) should be labeled as such in the header according to 37 CFR 1.121(d).
6. ☐ DEPOSIT OF and/or INFORMATION about the deposit of BIOLOGICAL MATERIAL must be submitted. Note the attached Examiner's comment regarding REQUIREMENT FOR THE DEPOSIT OF BIOLOGICAL MATERIAL.

Attachment(s)

- | | |
|---|---|
| <ol style="list-style-type: none"> 1. <input type="checkbox"/> Notice of References Cited (PTO-892) 2. <input type="checkbox"/> Notice of Draftsperson's Patent Drawing Review (PTO-948) 3. <input type="checkbox"/> Information Disclosure Statements (PTO-1449 or PTO/SB/08),
Paper No./Mail Date _____ 4. <input type="checkbox"/> Examiner's Comment Regarding Requirement for Deposit
of Biological Material | <ol style="list-style-type: none"> 5. <input type="checkbox"/> Notice of Informal Patent Application (PTO-152) 6. <input checked="" type="checkbox"/> Interview Summary (PTO-413),
Paper No./Mail Date <u>Hereto</u>. 7. <input checked="" type="checkbox"/> Examiner's Amendment/Comment 8. <input checked="" type="checkbox"/> Examiner's Statement of Reasons for Allowance 9. <input type="checkbox"/> Other _____ |
|---|---|

EXAMINER'S AMENDMENT

An examiner's amendment to the record appears below. Should the changes and/or additions be unacceptable to applicant, an amendment may be filed as provided by 37 CFR 1.312. To ensure consideration of such an amendment, it **MUST** be submitted no later than the payment of the issue fee.

Authorization for this examiner's amendment was given in a telephone interview with Mr. Felipe Hernandez and Mr. Mark Hanley on February 22, 2006.

IN THE CLAIMS

Claim 10 has been amended as follows:

10. (Currently Amended) A method of controlling flare, comprising:
- moving a material through a roll-forming process;
 - determining a location of the material within the roll-forming process; and
 - automatically varying a position of a roller based on the location of the material within the roll-forming process to change a flare characteristic associated with a zone of the material as the material moves through the roll-forming process.

Claim 14 has been amended as follows:

14. (Currently Amended) A method of controlling flare, comprising:
- moving a material through a roll-forming process; and

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automatically varying a position of a roller based on a material characteristic of the material to change a flare characteristic associated with a zone of the material as the material moves through the roll-forming process.

Claim 22 has been amended as follows:

22. (Currently Amended) An apparatus for controlling flare, comprising:
- a processor system including a memory; and
 - instructions stored in the memory that enable the processor system to:
 - detect a material moving through a roll-forming process;
 - automatically vary a position of a roller to change a flare characteristic associated with a zone of the material as the material moves through the roll-forming process; and
 - determine a location of the material within the roll-forming process.

Claim 27 has been amended as follows:

27. (Currently Amended) An apparatus for controlling flare, comprising:
- a processor system including a member; and
 - instructions stored in the memory that enable the processor system to:
 - detect a material moving through a roll-forming process;
 - automatically vary a position of a roller based on a material characteristic associated with a zone of the material as the material moves through the roll-forming process.

Claim 43 has been amended as follows:

43. (Currently Amended) A system for controlling flare, comprising:
a roller configured to vary a flare characteristic of a material; and
a position adjustment system coupled to the roller and configured to automatically adjust the roller based on a location of the material to condition the flare characteristic associated with a zone of the material.

Claim 45 has been amended as follows:

45. (Currently Amended) A system for controlling flare, comprising:
a roller configured to vary a flare characteristic of a material;
a position adjustment system coupled to the roller and configured to automatically adjust the roller to condition the flare characteristic associated with a zone of the material;
a processor system communicatively coupled to the position adjustment system and configured to cause the position adjustment system to adjust the roller; and
a sensor communicatively coupled to the processor system and configured to generate location information associated with the location of the material and convey the location information to the processor system.

REASONS FOR ALLOWANCE

The following is an examiner's statement of reasons for allowance: One reason for allowance is that the prior art of record, particularly the references to Toutant et al. and Trishevsky et al., do not show the feature of adjusting the position of the roller as the material is

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fed through the roll forming process to change or condition the flare characteristic associated with a zone of the material. In this regard, the flare characteristic is changed based upon a distinct region or area of the material, thus, resulting in a change in the flare characteristic. Applicant clearly describes this change in flare characteristic in Figures 8A and 8B and paragraph [0048] of the specification.

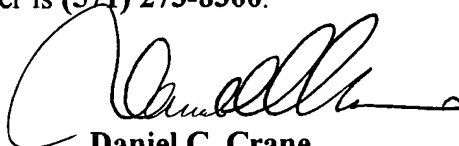
Any comments considered necessary by applicant must be submitted no later than the payment of the issue fee and, to avoid processing delays, should preferably accompany the issue fee. Such submissions should be clearly labeled "Comments on Statement of Reasons for Allowance."

INQUIRIES

Any inquiry concerning this communication or earlier communications from the examiner should be directed to Examiner D. Crane whose telephone number is (571) 272-4516. The examiner's office hours are 6:30 AM – 5:00 PM, Tuesday through Friday. The examiner's supervisor, Mr. Derris Banks, can be reached at (571) 272-4419.

Documents related to the instant application may be submitted directly by facsimile transmission at all times. The Examiner's Fax number is (571) 273-4516. Applicant(s) is(are) reminded to clearly mark any transmission as "DRAFT" if it is **not** to be considered as an official response. The Office Facsimile Center number is (571) 273-8300.

DCCrane
February 22, 2006



Daniel C. Crane
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Group Art Unit 3725